

Date: Friday, 7/21/2006 7:36:46 AM
 User: Kim Johnston

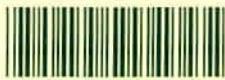
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 28011		
Estimate Number	: 10255		
P.O. Number	: N/A	Part Number	: D22301
This Issue	: 7/21/2006 S.O. No. : N/A	Drawing Number	: D2230 REV F
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: F
Previous Run	: 25554	Material	: N/A
Written By	:	Due Date	: 8/12/2006 Qty: 160 Um: Each
Checked & Approved By	: <u>KA 06.07.21</u>		
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

36

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
		Comment: Qty.: 0.0717 f(s)/Unit Total : 11.4744 f(s) Lug Extrusion D2423 Extrusion Batch: <u>B23119</u> MS 06108110
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch: <u>B23119</u> MS 06108110 X 16#
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 PG Issue P.O <u>1831</u> c204108115 (16#)
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling Machine per drawing D2230 Rev.F
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE R6 Receive + Inspect 106/08/01 164
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC3	SECOND CHECK Jab-08-31 Granted (164)
		Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: Date: 06/09/06

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Friday, 7/21/2006 7:36:47 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 28011

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC 06 09 01

(64)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 06 09 01

(64)

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

AM 06 09 01

(364)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10/4/01 (64)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

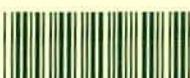
Identify and Stock

Location: 5T370

10/4/01 64

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10/4/01 (64)
PQ 06/09/05

Job Completion



10/4/01 (64)
PQ 06/09/05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

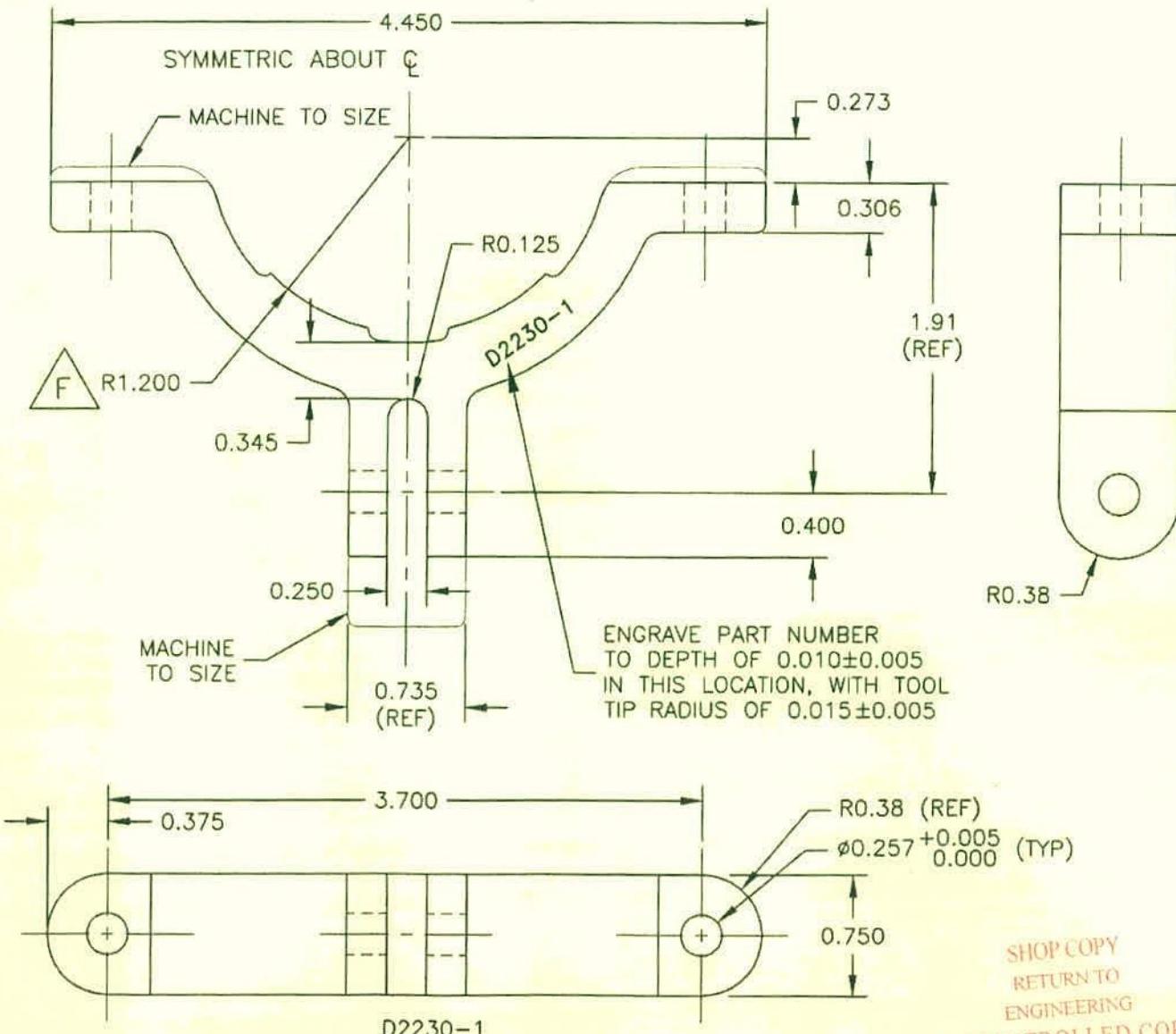
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART



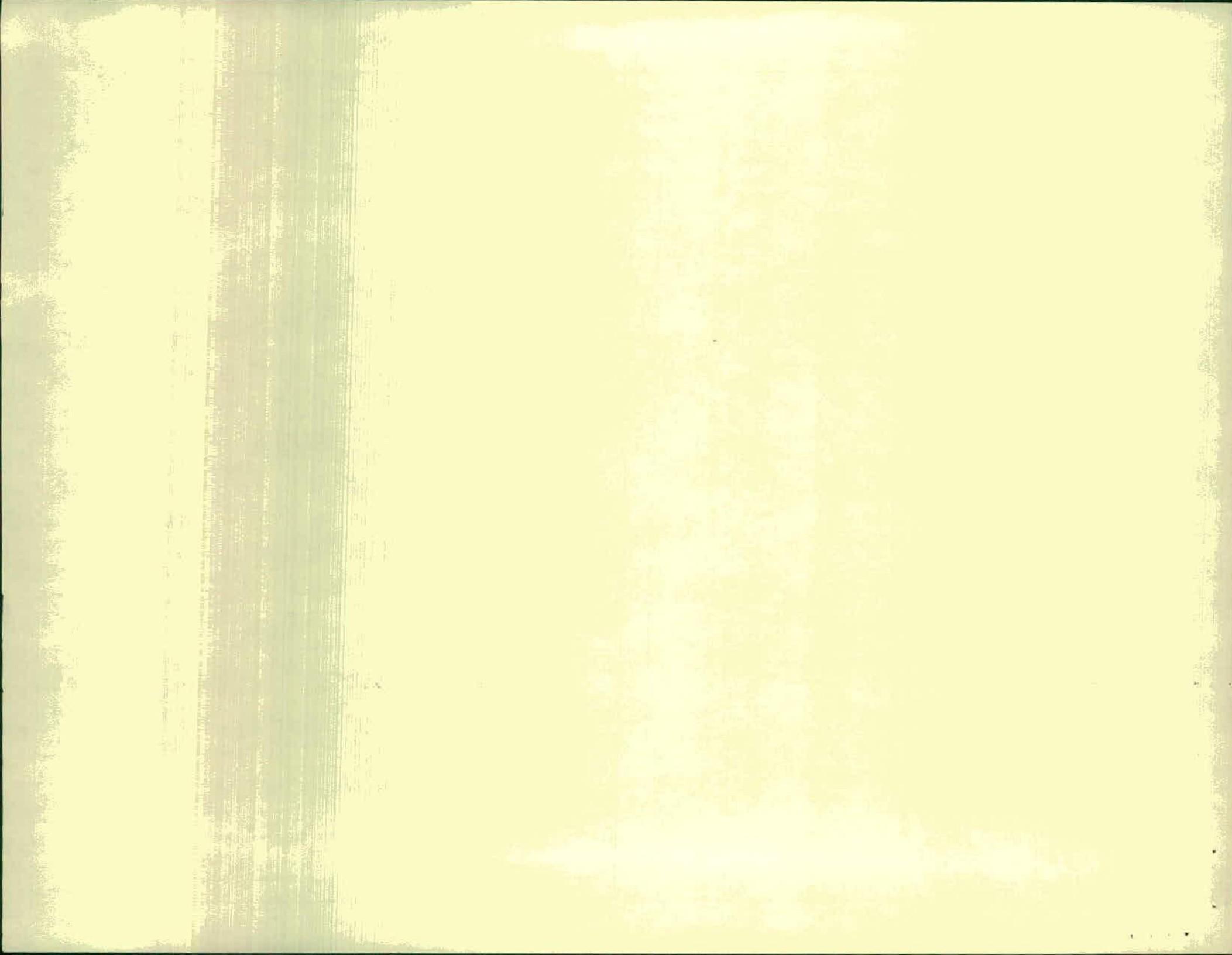
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
99.12.21 PS



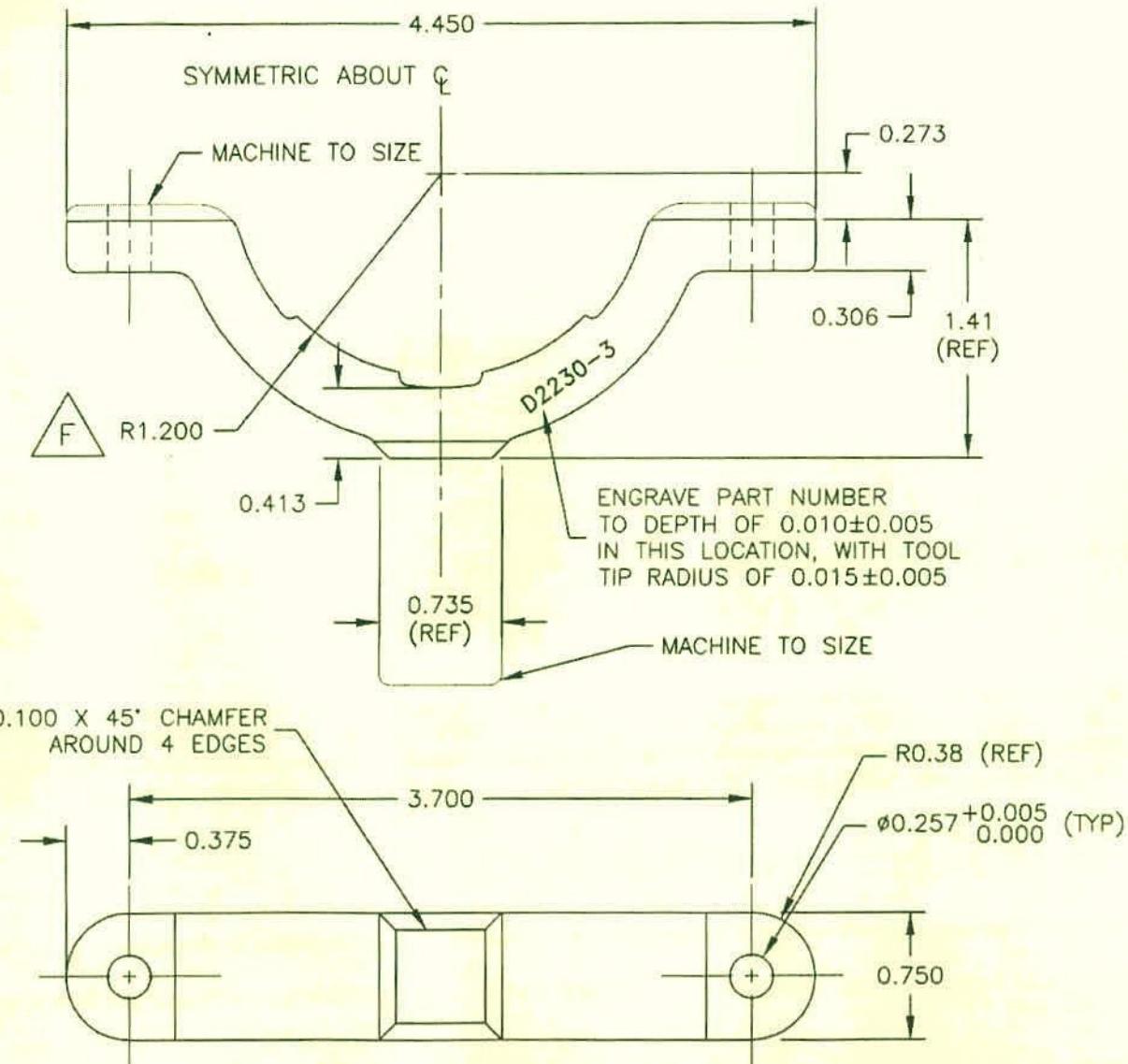
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000–0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28011

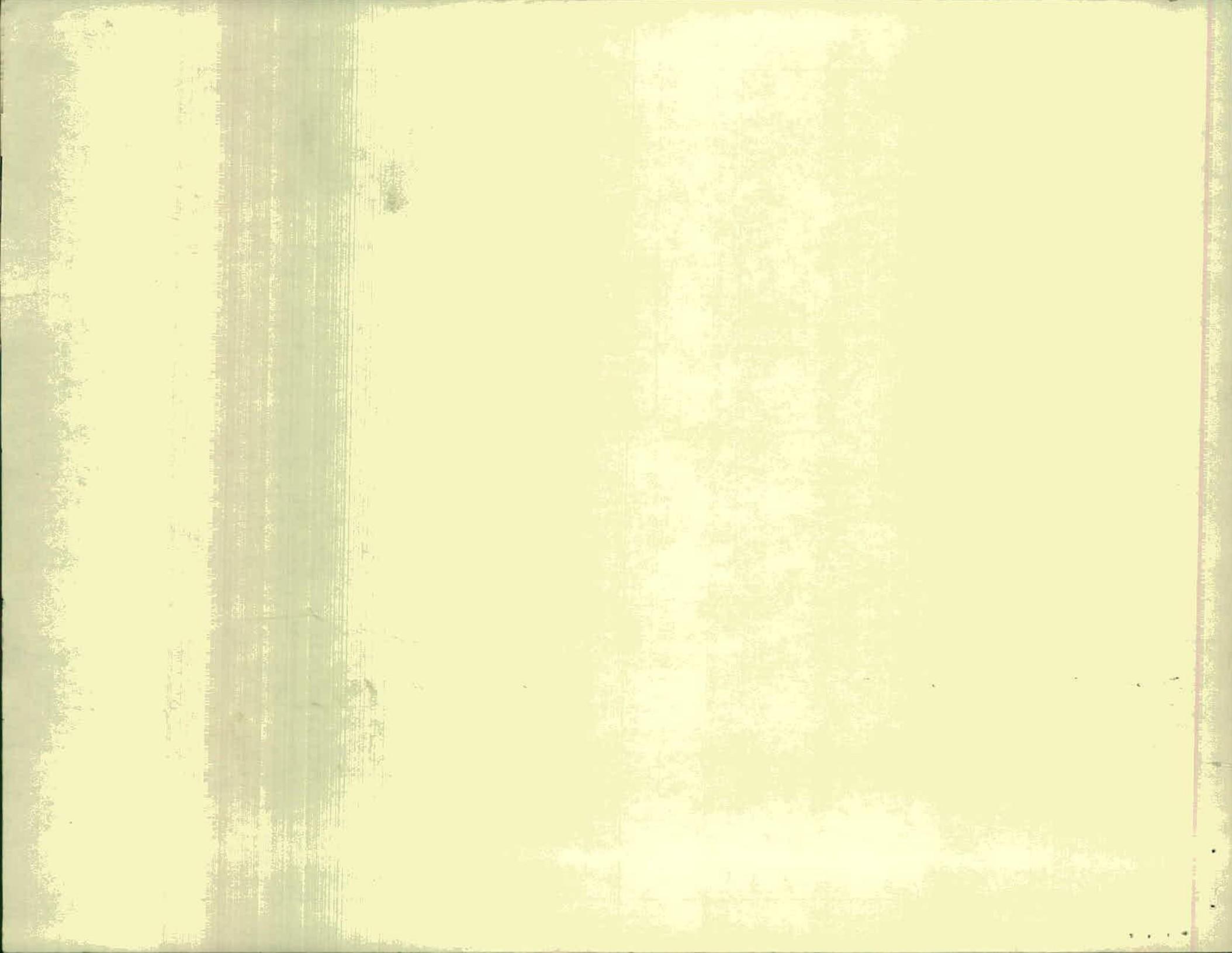


DART

DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
19.12.21 DS

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WORK ORDER
NO. *28011*





CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
164	D 2230-1	Mounting Lug	1381

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shig (Regula) Walz

Vankleek Hill, August 31, 2006

